

Date: Friday, 9/29/2006 10:43:26 AM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : STEP SPACER
<b>Job Number</b> : 28791D	
<b>Estimate Number</b> : 10356	
<b>P.O. Number</b> : <i>N/A</i>	<b>Part Number</b> : D2279
<b>This Issue</b> : 9/29/2006 <b>S.O. No.</b> : <i>N/A</i>	<b>Drawing Number</b> : D2279 REV D
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : D
<b>Previous Run</b> : 27756D	<b>Material</b> : <i>N/A</i>
<b>Written By</b> : _____	<b>Due Date</b> : 10/10/2006 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature]</i>	
<b>Comment</b> : Est Rev: A New Issue 05-11-07 JLM Est Rev: B Now on Waterjet 06-07-03 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M2024T3S040	2024-T3 .040 sheet
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**Comment:** Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s)  
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick  
 (M2024T3S.040)  
 Identify as D2279  
 Batch: *M102448*

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D 2279  
 Dwg Rev: *BD*  
 Prog Rev: *D*

2-Deburr if necessary

*SAD 06:10:28 20*  
*SAD 06:10:30 20*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE*SAD 06:10:28 20*

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

*06-10-30 (20)*  
*ccw/led*

5.0	BRAKE NC	NC BRAKE
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**Comment:** NC BRAKE  
 Form As per Dwg D2279

*SB 06/11/20 (20)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: 20 Date: 06/11/27  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:43:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 28791D

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/11/20 (20)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FC  
y

06/11/22 x 20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/11/23 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/11/23 20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(20)  
06/11/27

Job Completion



06.11.27

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

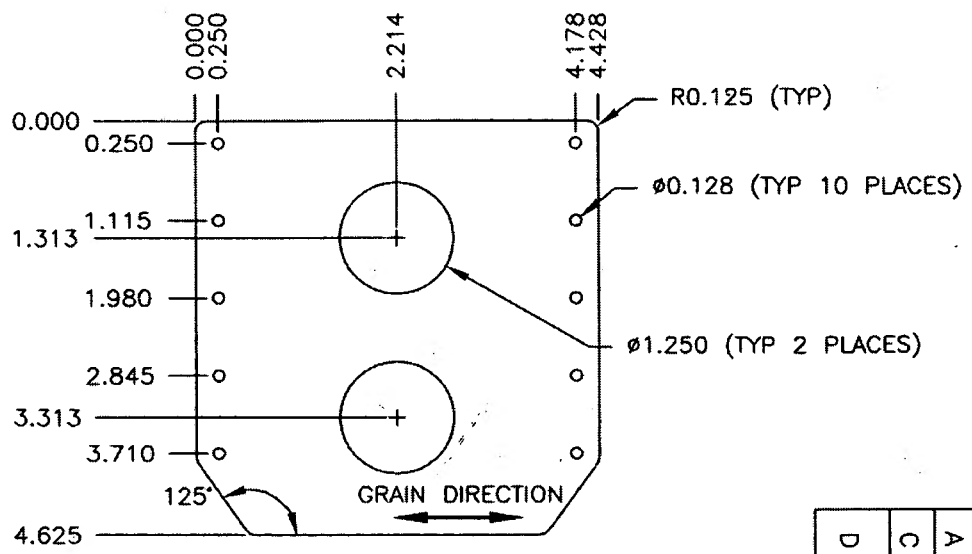
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



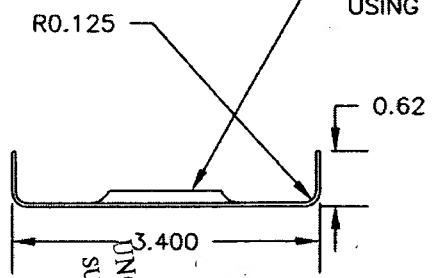
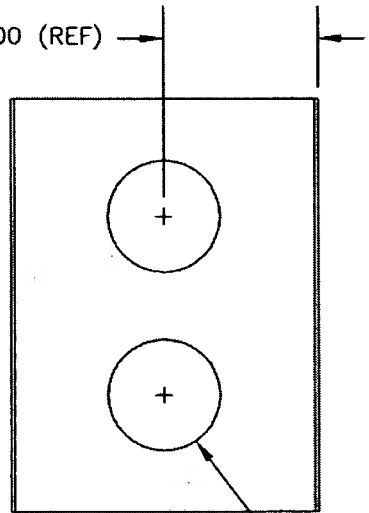
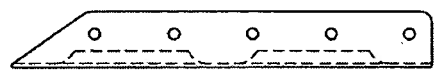


DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. D
BW	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JP	DRAWING NO. D2279	SHEET 1 OF 1
DATE 98.10.05	TITLE STEP SPACER	SCALE 1:2	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	



FLAT LAYOUT

FLANGE AFTER BENDING  
TOWARDS INSIDE OF PART  
USING DT8174 (2 PLACES)



RELEASED  
98.10.08 DS

UNDER REVIEW  
98.10.15 JP  
DESIGN OK, BUT CHECK WITH  
TS BEFORE MANUFACTURE  
OK (signed)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28791D

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

